

Date: Tuesday, 12/5/2006 8:19:34 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 29811	
Estimate Number : 10008	
P.O. Number : N/A	Part Number : D2591
This Issue : 12/5/2006 S.O. No. : N/A	Drawing Number : D2591 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 29624	Material : N/A
Written By : <u> </u>	Due Date : 12/23/2006 Qty: 40 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:1 Removed from 9 Digit 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
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Comment: Qty.: 0.2340 f(s)/Unit Total : 9.3600 f(s)
 ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)
 Batch: M103069

ml 07/01/07

40

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.700" long

ml 07/01/07

40

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

JL/J.F.

07/01/28

(40)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/J.F.

07/01/28

(40)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 07/01/28

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: PD Date: 07/01/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CAL

P 07/01/29

(40)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

P 07/01/29

Job Completion



U 07-01-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

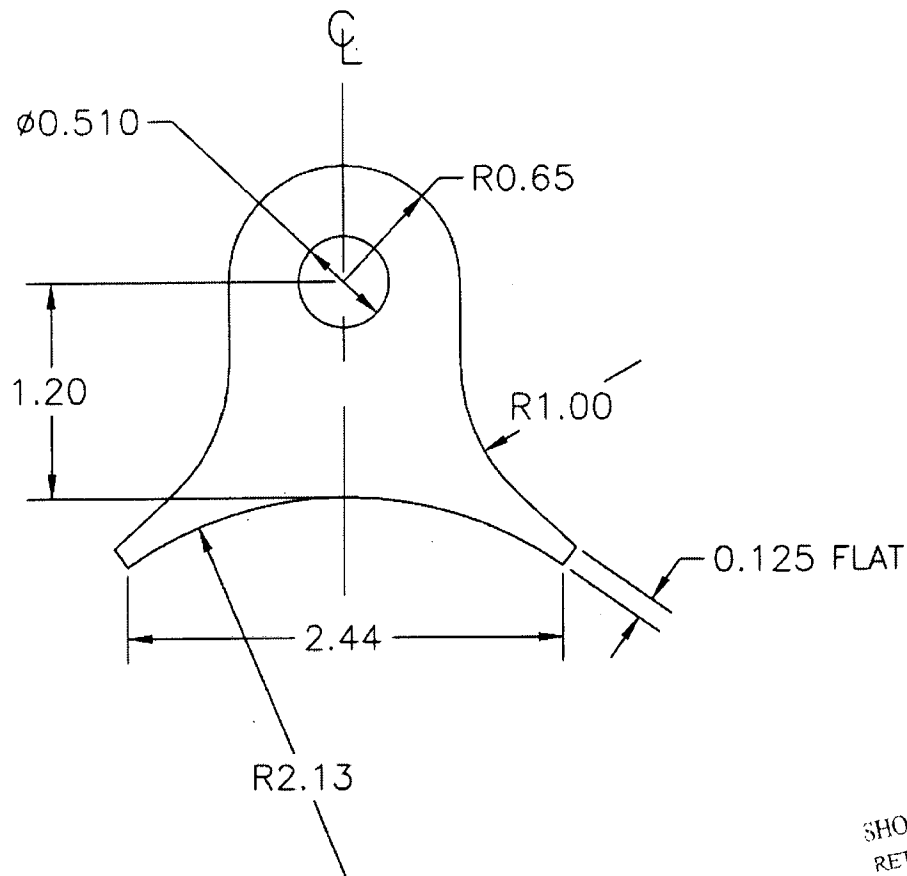
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>max</i>	DRAWN BY <i>max</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM.	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
98.01.21 DS



BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~
MATERIAL: ASTM A36 STEEL 0.50 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER-LINE
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29811